

Date: Tuesday, 11/22/2005 4:58:32 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FWD MOUNTING LUG
 Job Number : 24943
 Estimate Number : 10453
 P.O. Number : *N/A*
 This Issue : 11/22/2005 S.O. No. : *N/A*
 Prsht Rev. : NC
 First Issue : 11/22/2005 Type : MACHINED PARTS
 Previous Run : 24748
 Part Number : D26162
 Drawing Number : D2616 REV D3
 Project Number : N/A
 Drawing Revision : D3
 Material : *N/A*
 Due Date : 12/2/2005 Qty: 30 Um: Each
 Written By : *See comment below*
 Checked & Approved By : *See comment below*
 Comment : Est Rev:C 00.06.22 Removed P/O for powder coat EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B1000X02000 6061-T6 Bar 1.0" x 2.0"



Comment: Qty.: 0.1749 f(s)/Unit Total: 5.2479 f(s)
 Material: 6061-T6 QQ-A-200/8 2" X 1" Bar
 Batch *M19059*

ml 05/11/24 30

2.0 BAND SAW BAND SAW



Comment: BAND SAW
 Cut blanks: 2.000" long +0.030" -0.000"

ml 05/11/24 30

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per folio D2616-2 & DWG D2616

2-Tumble & Deburr

MS 05/11/27 30

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS 05/11/27 30

5.0 QC8 SECOND CHECK



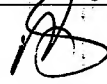



Comment: SECOND CHECK

SP 05/11/28 30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 05/12/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
5/11/26	3	1 piece too small the piece move in the vise 1 piece scrap, program was wrong	 QMD	destroy and replace	ml 05/11/26	 05-11-28	 QMD	 05-11-28

NOTE: Date & initial all entries

Date: Tuesday, 11/22/2005 4:58:32 PM

User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD MOUNTING LUG

Job Number: 24943

Part Number: D26162

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

ml 05/11/29 30

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

Note: Mask large hole

ml 05/11/29 30

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

J 05.11.30 30

9.0

D2611

Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 30.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2611	Bearing	B24411

P70

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Coat bearing in light oil

2-Press Bearing in D2616-2

3-Stack as per Dwg D2616 using DT8019

4- Touch up paint if required

SB 05/11/30

SB 05/11/30

11.0

QC5

INSPECT WORK TO CURRENT STEP



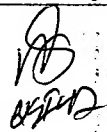
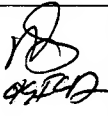
Comment: INSPECT WORK TO CURRENT STEP

J 05.11.30 30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 05/12/00
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05-11-30	9	Parts were noticed to be 0.8150.0.003" over max dimension of 0.8120. bearing can be installed dry by hand, barely any press R+ required.		Parts are acceptable state bearing in 8 places each side	SB 05/11/30	2 05-11-30		2 05-11-30

NOTE: Date & initial all entries

Date: Tuesday, 11/22/2005 4:58:32 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD MOUNTING LUG

Job Number: 24943

Part Number: D26162

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 140

10 05/12/01 30

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

545 05/12/05 30 05/12/02 30

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

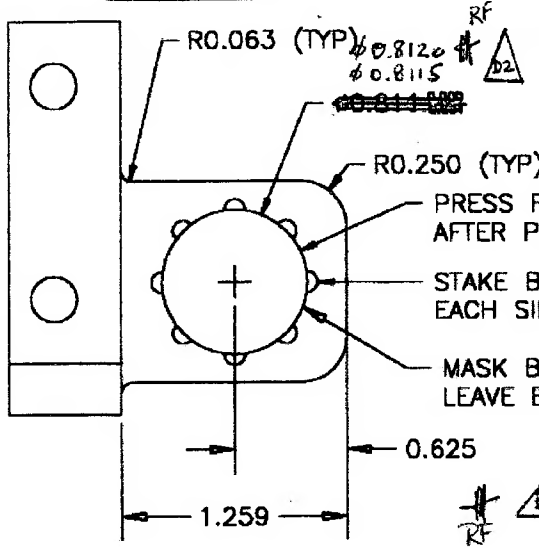
NOTE: Date & initial all entries



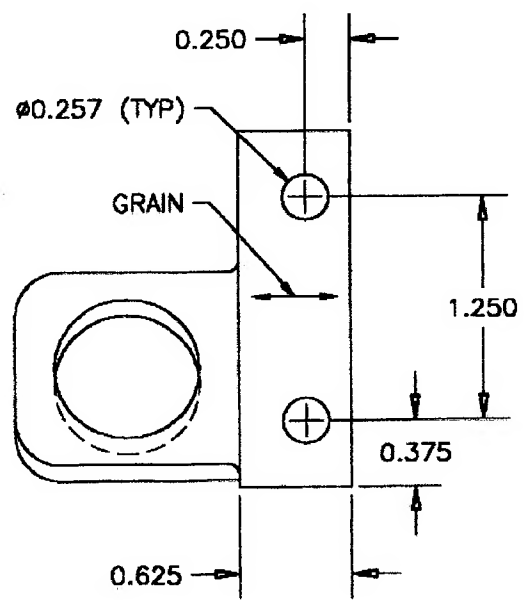
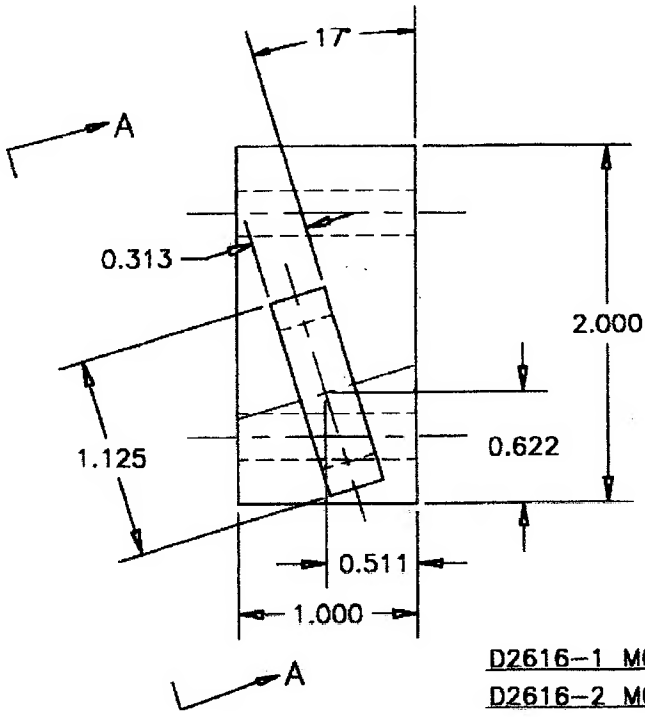
DESIGN BW	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED BW	DRAWING NO. D2616	REV. D SHEET 1 OF 1
DATE 97.07.31		TITLE FWD MOUNT LUG	SCALE 1:1

D1	99.12.16	STAKE 4 PLS INSTEAD OF 8 PLS/SIDE	A	96.10.20	ORIGINAL ISSUE
D2	00.11.21	CHG. HOLE TOL. PER NCR 449.	B	97.05.06	RE-DESIGN
D3	02.04.30	ADD STAKING NOTE PER CAR 107	C	97.06.04	REMOVE D2616-3
			D	97.07.31	D2611 WAS CBA-6-B2

VIEW A-A



STAKING NOTE:
D2611 BEARING MUST BE STAKED TO PREVENT TRANSLATION BUT TO STILL ALLOW ROTATION USING DTB 19. TOUCH UP PAINT AFTER STAKING.



DART AEROSPACE LTD		Work Order:	24943
Description: FWD MOUNTING Lug		Part Number:	D2616-2
Inspection Dwg: D2616 Rev: D3		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

[illegible]

Measured by:	<i>[Signature]</i>	Audited by:	<i>MS</i>	Prototype Approval:	<i>[Signature]</i>
Date:	<i>05/11/26</i>	Date:	<i>05/11/26</i>	Date:	<i>N/A</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

[illegible]

Measured by:	
Date:	

Audited by:	
Date:	

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	